

15/36

DART AEROSPACE LTD	Work Order:	24080
Description: Long Step Assembly – High Skid, RH	Part Number:	D350-591-312
		704A 41 640011
Dwg: D3272 Rev. A	Qty:	10
		Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	KJ	05.08.23	10
2	DC	Photocopy bluefile and type labels as per PPP D350-591,312 CHG001	DIT	05.08.25	10
3	GA	Cut D2622-120C extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A. Pick: Qty Part Number Description Batch 1 D2622-120C Extrusion 324092	le	06.02.18	10
4	GA	Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.	le	06.02.20	10
5	GA	Deburr	le	06.02.20	10
6	QC5	Inspect work to Step 5	le	06.02.20	10
7	WA	Bevel end for welding FWD ONLY	le	06.02.20	10
8	WA	Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272 Pick: Qty Part Number Description Batch 1 D3067-1 End Plate 324097 2 D3219-1 Support 324094-10 324507-10 A/R Aluminum Rod M18838 & M18839	le	06.02.20	10
9	GA	Grind End Plate flush	FF	06.02.22	10
10	QC9 & 5	Inspect weld and work to Step 9	PD	06.02.22	10
11	FP	Chemical conversion coat as per QSI 005 4.1	FF	06.02.27	10
12	GA	Assemble Leg Assembly as per Dwg D3272. (D3066-1 is part of D3065-041 Step Leg Assembly, do not add to BOM.) Pick: Qty Part Number Description Batch 1 D3065-041 Step Leg Assy 324093 2 D3066-1 Spacer 325056 16 MS20600AD4W4 Rivet M19185	le	06.03.2	10
13	QC5	Inspect work to step 12	PD	06.03.03	10
14	WA	Bevel Aft end for welding	le	06.03.3	10
15	WA	Inspect for foreign object as per QSI 024	le	06.03.3	10
16	WA	Weld Aft End Plate as per QSI 004 & Dwg D3272 Pick: Qty Part Number Description Batch 1 D3067-1 End Plate 324097 A/R Aluminum Rod M18838 Identify as D3272-042	le	06.03.3	10

RELEASED
04.03.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 06/03/15

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	24080
Description: Long Step Assembly – High Skid, RH		Part Number:	D350-591-312
Dwg: D3272 Rev. A		Qty:	10
		Page 2 of 2	

Step	Location	Procedure	By	Date	Qty																																																																
17	GA	Grind End Plate flush	JE	06-03-13	10																																																																
18	QC9 & 5	Inspect work to Step 17 – Check dimension 108.93" & 3.375" as per Dwg D3272	MA	06/03/06	10																																																																
19	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	Q.M	06-03-14	10																																																																
20	FP	Wing Walk as per Dwg D3272 and QSI 005 4.4	DL	06/03/14	10																																																																
21	QC3	Inspect Powder Coat and Wing Walk	MC	6/3/14	10																																																																
22	KP	<p>Pick: Packing Kit (Note: D3272-042 is on BOM as material listed in Step 3)</p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>4</td><td>D2230-3</td><td>Mounting Lug</td><td>B24090 ✓</td></tr><tr><td>2</td><td>D2618</td><td>Bushing</td><td>B24091 ✓</td></tr><tr><td>2</td><td>D2856-400-720</td><td>Abrasion Strip</td><td>B24237B ✓</td></tr><tr><td>2</td><td>D3235-1</td><td>Mounting Lug</td><td>B24567 ✓</td></tr><tr><td>1</td><td>D3272-042</td><td>Step Assembly</td><td>B24080</td></tr><tr><td>1</td><td>D3278-041</td><td>Support Assembly</td><td>B24096</td></tr><tr><td>2</td><td>AN3-35A</td><td>Bolt 12x 11/6/14</td><td>8x B17944</td></tr><tr><td>8</td><td>AN4-13A</td><td>Bolt</td><td>m18369</td></tr><tr><td>2</td><td>AN5-36A</td><td>Bolt</td><td>m16114 ✓</td></tr><tr><td>4</td><td>AN960JD10</td><td>Washer</td><td>m19521 ✓</td></tr><tr><td>16</td><td>AN960JD416</td><td>Washer</td><td>m19085 ✓</td></tr><tr><td>4</td><td>AN960JD516</td><td>Washer</td><td>m18100 ✓</td></tr><tr><td>2</td><td>MS21042L3 ✓</td><td>Nut (or -3)</td><td>m18917 ✓</td></tr><tr><td>8</td><td>MS21042L4 ✓</td><td>Nut (or -4)</td><td>m17997 ✓</td></tr><tr><td>2</td><td>MS21042L5 ✓</td><td>Nut (or -5)</td><td>m19073 ✓</td></tr></tbody></table>	Qty	Part Number	Description	Batch	4	D2230-3	Mounting Lug	B24090 ✓	2	D2618	Bushing	B24091 ✓	2	D2856-400-720	Abrasion Strip	B24237B ✓	2	D3235-1	Mounting Lug	B24567 ✓	1	D3272-042	Step Assembly	B24080	1	D3278-041	Support Assembly	B24096	2	AN3-35A	Bolt 12x 11/6/14	8x B17944	8	AN4-13A	Bolt	m18369	2	AN5-36A	Bolt	m16114 ✓	4	AN960JD10	Washer	m19521 ✓	16	AN960JD416	Washer	m19085 ✓	4	AN960JD516	Washer	m18100 ✓	2	MS21042L3 ✓	Nut (or -3)	m18917 ✓	8	MS21042L4 ✓	Nut (or -4)	m17997 ✓	2	MS21042L5 ✓	Nut (or -5)	m19073 ✓	CR	06/03/15	10
Qty	Part Number	Description	Batch																																																																		
4	D2230-3	Mounting Lug	B24090 ✓																																																																		
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2	MS21042L5 ✓	Nut (or -5)	m19073 ✓																																																																		
23	QC4	Inspect Kit 100% for Completeness on the W/O	REV B	6/3/15	10																																																																
24	PK	Package for shipping as per PPP D350-591-312	REV B	6/3/15	10																																																																
25	AC	Cost / part	W	06/03/15	10																																																																
26	DC	Close W/O Inspect Level 21	W	06/03/15	10																																																																

Rev	Date	Change	Revised By	Approved
A	04.03.22	New issue	KJ/RF	

RELEASED
04.03.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

5/36

DART AEROSPACE LTD	Work Order:	24080
Description: Long Step Assembly – High Skid, RH	Part Number:	D350-591-312
Dwg: D3272 Rev. A	Qty:	10
		Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required		05.08.23	10
2	DC	Photocopy bluefile and type labels as per PPP D350-591-312 CHG001		05.08.30	10
3	GA	Cut D2622-120C extrusion to 116.25" long as per Dwg D3272 using cutting table Setup DT 8185-2A. Pick: Qty Part Number Description Batch 1 D2622-120C Extrusion			
4	GA	Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.			
5	GA	Deburr			
6	QC5	Inspect work to Step 5			
7	WA	Bevel end for welding FWD ONLY			
8	WA	Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272 Pick: Qty Part Number Description Batch 1 D3067-1 End Plate 2 D3219-1 Support A/R Aluminum Rod			
9	GA	Grind End Plate flush			
10	QC9 & 5	Inspect weld and work to Step 9			
11	FP	Chemical conversion coat as per QSI 005 4.1			
12	GA	Assemble Leg Assembly as per Dwg D3272. (D3066-1 is part of D3065-041 Step Leg Assembly, do not add to BOM.) Pick: Qty Part Number Description Batch 1 D3065-041 Step Leg Assy 2 D3066-1 Spacer 16 MS20600AD4W4 Rivet			
13	QC5	Inspect work to step 12			
14	WA	Bevel Aft end for welding			
15	WA	Inspect for foreign object as per QSI 024			
16	WA	Weld Aft End Plate as per QSI 004 & Dwg D3272 Pick: Qty Part Number Description Batch 1 D3067-1 End Plate A/R Aluminum Rod Identify as D3272-042			

REFERENCE ONLY

RELEASED
04.03.22

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 18, 2005
10:59 am

Work Order No : 0024080
Project Name : D350-591-312
Project For : WK536
Work Order Type : Main
Main WO Number :
House Part Number : *D350-591-312
Description : Heli-Access-Step, RH Hi
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 08-16-05
Est Finish Date : 09-09-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
10:51 am

Work Order No : 0024080
Project Name : D350-591-312
Project For : WK536
Work Order Type : Main
Main WO Number :
House Part Number : *D350-591-312
Description : Heli-Access-Step, RH Hi
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 08-16-05
Est Finish Date : 09-09-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

*MIS open bal
26
11-11*

Date: Wednesday, 11/9/2005 12:40:59 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LONG STEP ASSEMBLY HIGH SKID LH
Job Number : 24080	
Estimate Number : 10274	
P.O. Number :	Part Number : D350591312
This Issue : 11/9/2005 S.O. No. :	Drawing Number : D3272 REV A
Prsht Rev. : NC	Project Number :
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 23824	Material :
Written By :	Due Date : 11/30/2005 Qty: 10 Um: Each
Checked & Approved By :	
Comment : Est Rev:A 04.03.22 New issue KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

2.0	D2622120C	Extrusion
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3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.

3-Deburr

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

5.0	D30671	End Plate
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6.0	D32191	Support
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7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod _____

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 24080

Part Number: D350591312

Job Number:



Seq. #:	Machine Or Operation:	Description :
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3-Grind End Plate flush

8.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and work to Step 9

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

D3065041

Step Leg Assembly

12.0

D30661

Spacer

13.0

MS20600AD4W4

Rivets

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble Leg Assembly as per Dwg D3272.

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

16.0

D30671

End Plate

17.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod _____

4-Grind End Plate flush

Date: Wednesday, 11/9/2005 12:41:00 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 24080

Part Number: D350591312

Job Number:



Seq. #:	Machine Or Operation:	Description :
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18.0	QC5/9	WELD INSPECTION
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Comment: Inspect work & Weld to Current - Check dimension 108.93" & 3.375" as per Dwg D3272

19.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

20.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3272 and QSI 005 4.4

21.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: Inspect Powder Coat and Wing Walk

22.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

23.0	D22303	Mounting Lug
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24.0	D2618	Bushing
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25.0	D2856400720	Abrasion Strip
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26.0	D32351	Mounting Lug
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27.0	D3272041	Step Assembly
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28.0	D3278041	Support Assembly
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29.0	AN335A	Bolt
------	--------	------

30.0	AN413A	Bolt
------	--------	------

31.0	AN536A	BOLT
------	--------	------

32.0	AN960JD10	Washer
------	-----------	--------

33.0	AN960JD416	Washer
------	------------	--------

34.0	AN960JD516	Washer
------	------------	--------

35.0	MS21042L3	Nut
------	-----------	-----

36.0	MS21042L4	Nut
------	-----------	-----

Date: Wednesday, 11/9/2005 12:41:00 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 24080

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0

MS21042L5

Nut

38.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

39.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-311

Location: _____

40.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

